

Date: Friday, 11/18/2005 2:08:28 PM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	FLOAT SKIDTUBE ASSEMBLY
<b>Job Number</b> :	24796A		
<b>Estimate Number</b> :	10309		
<b>P.O. Number</b> :		<b>Part Number</b> :	D206642541
<b>This Issue</b> :	11/18/2005	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3274 REV C
<b>First Issue</b> :	//	<b>Project Number</b> :	
<b>Previous Run</b> :	24795A	<b>Drawing Revision</b> :	C
		<b>Material</b> :	
<b>Written By</b> :		<b>Due Date</b> :	12/20/2005
<b>Checked &amp; Approved By</b> :		<b>Qty:</b>	1 Um: Each
<b>Comment</b> :	Est Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	D26001240	Extrusion Round 3" 206
-----	-----------	------------------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
 Pick:

Qty Part Number Description Batch

1 D2600-1-240 3" OD Tube B10427 DP05-11-23

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------

**Comment:** LANDING GEAR RESOURCE 1

1-Cut D2600-1 to 190.00" in length as per Dwg D3274 and Deburr ends DP05-11-23

2-Drill #40 Aft cap pilot hole using DT8025 DP05-11-23

3-Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274 DP05-11-23

4-Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 DP05-11-24

5-Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end. DP05-11-24

6-Open Ø0.313" crossbolt spacer holes using DT8743 as per Dwg D3274 Pm 05-11-28

7-Open Ø0.375" crossbolt spacer holes using DT8744 as per Dwg D3274 Pm 05-11-28

8-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube 05-11-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/18/2005 2:08:29 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 24796A

Part Number: D206642541

Job Number:



Seq. #: Machine Or Operation: Description :

3.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid Etch and Alodine tube as per QSI 005 4.

AMOS-11-24

①

4.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 06-01-03

①

5.0

D3282041

I-Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3282-041 Float Web

B24862

DP 06-1-3

①

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Bond web in place as per Dwg D3274 & QSI 015.

A/R Sikaflex-291

M19134

Sikaflex expire date:

06-06-20

Start: 06-1-3

Time: 8:45

Finish: 06-1-4

Time: 1:45

(Adhere for 12 hours)

DP 06-1-4

①

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-01-04

①

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Bend tube using program D3274 as per Dwg D3274. Install drop pins in cross bolt spacer holes to maintain web position.

DP 06-1-4

①

2-Cut Fwd end of tube to length as per Dwg D3274

DP 06-1-4

①

3-Remove inner indexing ridge on Fwd end of skidtube as per Dwg D3274

BE 06-01-5

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/18/2005 2:08:29 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 24796A

Part Number: D206642541

Job Number:



Seq. #: Machine Or Operation: Description:

4-Drill pilot holes for wearplates using D3274-1T2, then open to Ø0.297". (without cutting fluid) *BE 06-01-05 (1)*

5-Deburr *BE 06-01-05 (1)*

6-C'sink cross bolt holes as per Dwg D3274 *BE 06-01-05*

9.0

D32851

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3285-1 Fwd Cap *B 21744 BE 06-01-06 (1)*

10.0

D2649

Crossbolt Spacer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 D2649 Crossbolt spacer *B 24200 BE 06-01-06 (1)*

11.0

D32751

Crossbolt Spacer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 D3275-1 Crossbolt spacer *m 15030 (2P) B 24861 (10R) BE 06-01-06 (1)*

12.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Weld Fwd Cap as per Dwg D3274 and QSI 004. Use aluminum rod.

A/R Aluminum Rod *m 15855 / m 18701 BE 06-01-06 (1)*

2-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod

A/R Aluminum Rod *m 15855 BE 06-01-06 (1)*

3-Grind welds flush to Fwd cap on top surface only.

4-Grind cross bolt welds flush as per Dwg D3274. Masking Tape access to inside of the skidtube *BE 06-01-09 (1)*

5-Counterbore 5/16" x 0.750" deep as per Dwg D3274. Use DT8743 visual aid Jig and deburr. *BE 06-01-09 (1)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/18/2005 2:08:29 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 24796A

Part Number: D206642541

Job Number:



Seq. #: Machine Or Operation: Description :

13.0 QC5/9 WELD INSPECTION



Comment: Inspect weld and Counterbore. Inspect for foreign objects as per QSI 024

2006-01-10  
PD 06-01-10 PTO

14.0 POWDER COATING POWDER COATING



Comment: POWDER COATING  
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FC 06-01-13

15.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06-01-13

16.0 D3415041 Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3415-041	Nut Plate	24574

FC 06 01 13

17.0 CCR264SS33 Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	CCR264SS3-3	Rivet	m18548

FC 06 01 13

18.0 CR3212403 Cherry Rivet





Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	CR3212-4-03	Rivet	m15918

FC 06 01 13

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06-01-10	8	C'sink detail not shown or described on Dwg.D32 74 (Rev.C), Add this detail too Dwg. Also ensure hole size is correct Ø.257  permanent change.					 06-01-10	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Friday, 11/18/2005 2:08:29 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 24796A

Part Number: D206642541

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

19.0	D26483	Wearpad
------	--------	---------



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
8	D2648-3	Wearpad	23978C

FC 06 01 13

20.0	D265615	Wearplate
------	---------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2656-15	Wearshoe	021712

FC 06 01 13

21.0	D265623	Wearplate
------	---------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2656-23	Wearshoe	022065

FC 06 01 13

22.0	D265635	Wearplate
------	---------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2656-35	Wearshoe	024148

FC 06 01 13

23.0	D32871	Wearshoe
------	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3287-1	Wearshoe	021719

FC 06 01 13

24.0	D34291	WEARPAD
------	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3429-1	Wearpad	024407

FC 06 01 13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/18/2005 2:08:29 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 24796A

Part Number: D206642541

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

25.0	AN960C10L	Inventory
------	-----------	-----------



Comment: Qty.: 78.0000 Each(s)/Unit Total : 78.0000 Each(s)

Pick:

Qty Part Number Description Batch

78 AN960C10L Washer m18822

FC 06 01 13

26.0	MS27039C108	SCREW
------	-------------	-------



Comment: Qty.: 78.0000 Each(s)/Unit Total : 78.0000 Each(s)

Pick:

Qty Part Number Description Batch

78 MS27039C1-08Screw m17460

FC 06 01 13

27.0	NAS1330C3KB116	Insert
------	----------------	--------



Comment: Qty.: 78.0000 Each(s)/Unit Total : 78.0000 Each(s)

Pick:

Qty Part Number Description Batch

78 NAS1330C3KB116 Inserts m19014

FC 06 01 13

28.0	NAS1515H3L	WASHER
------	------------	--------



Comment: Qty.: 78.0000 Each(s)/Unit Total : 78.0000 Each(s)

Pick:

Qty Part Number Description Batch

78 NAS1515H3L Washer m17450

FC 06 01 13

29.0	D34131	RING
------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3413-1 Ring m24222

FC 06 01 13

30.0	AN4C5A	BOLT
------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN4C5A Bolt m18918

FC 06 01 13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/18/2005 2:08:29 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 24796A

Part Number: D206642541

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

31.0	AN960C416L	Inventory
------	------------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN960C416L	Washer	<u>m18822</u>

FC 06 0113 1

32.0	NAS1515H4L	Inventory
------	------------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	NAS1515H4L	Washer	<u>m18918</u>

FC 06 0113 1

33.0	D2646	Aft Cap
------	-------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2646	Aft Cap	<u>233700</u>

FC 06 0113 1

34.0	AN960C10L	Inventory
------	-----------	-----------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN960C10L	Washer	<u>m18822</u>

FC 06 0113

35.0	MS27039C108	SCREW
------	-------------	-------



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
12	MS27039C1-08Screw		<u>m17460</u>

FC 06 0113

36.0	NAS1515H3L	WASHER
------	------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	NAS1515H3L	Washer	<u>m17450</u>

FC 06 0113

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/18/2005 2:08:29 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 24796A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

37.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets.

A/RN/ALPS-3 m17395

FC 06 01 14

2-Install inserts & wearpads as per Dwg D3274. Use a drop of Sikaflex inside insert holes and a layer of sikaflex between wearplates and skidtube.

A/R Sikaflex-291 m19134

Sikaflex expire date: 06 20 06

FC 06 01 14  
PTO

3-Install ring as per Dwg D3274

A/R Sikaflex-291 m19134

Sikaflex expire date: 06 20 06

FC 06 01 16

4-Inspect for foreign objects as per QSI 024

FC 06 01 16

5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R Sikaflex-291 m19134

Sikaflex expire date: 06 20 06

FC 06 01 16

38.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

m 06 01 16

39.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

① 06/01/18

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
05-01-12	37	Spray inside of tube with LPS 3 <u>Permanent Change</u>				<i>[Signature]</i> 05-01-12	<i>[Signature]</i> 05-01-12	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Wednesday, 10/01/2007 7:21:54 AM

User: Linda Lacelle

**JOB HISTORY : DETAIL**

<b>Job Number</b>	: 24796A	<b>Customer</b>	: Dart Helicopters Services
<b>Estimate Number</b>	: 10309	<b>DWG Name</b>	: FLOAT SKIDTUBE ASSEMBLY
<b>Purchase Order #</b>	:	<b>Part Number</b>	: D206642541
<b>Complete Date</b>	: 18/01/2006 12:23:17	<b>DWG Number</b>	: D3274 REV C
		<b>Rev.</b>	: C

<b>DUE DATE</b>	<b>ORDERED</b>	<b>DELIVERED</b>
20/12/2005	1	1

**14.0 POWDER COATING** *Internal Operation*

<b>DATE</b>	<b>EMPLOYEE</b>	<b>TYPE</b>	<b>Qty</b>	<b>Time(hrs)</b>	<b>COST</b>	<b>MTime(hrs)</b>	<b>Mach.Cost</b>
16/01/2006	CHAR03: Charlebois, Francis	Run	0.000	2.50	\$30.68	2.50	182.50

<b>Subtotal:</b>	QTD:	0	CTD:	0	2.50	\$213.18
------------------	------	---	------	---	------	----------

		<b>TIME</b>	<b>COST</b>
	Machine Time:	2.50	\$182.50
	Labor:	2.50	\$30.68
	Sub-contract (external Op.):		\$0.00
	INVENTORY ITEM:		\$0.00
	SUB-COMPONENT (SUB-JOB):		\$0.00
<b>Total:</b>			\$213.18

<b>COST PER UNIT:</b>	\$213.18
-----------------------	----------